

SPUT-1
Work Order ID 69556-1

Thursday, May 12, 2011 8:25:04 AM



Page 1

Item ID: D3290-3

Accept



Setup

Start



Revision ID:

Item Name: Window

Stop



Start Date: 5/12/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

u

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3290

Rev C

100



FLOW WATER JET

0.00

104-5-12

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290

Dwg Rev

C

Prog Rev.

C

2-

Deburr if necessary

18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

104-5-12

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

S. Miller

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69556

Thursday, May 12, 2011 8:25:04 AM



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Item ID: D3290-3

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Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

HAND FINISHING THERMOFORMING

0.00

x18.

SL

Thermoform

Thermoforming Machine

Memo

0.00

140



THERMOFORMING MACHINE

0.00

x17

x1

SL

Thermoform

Thermoforming Machine

Memo

0.00

1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg
Rev. C Folio Rev. B 12-Engrave part# &
batch#, (D3290-3)

11/05/13

PTO →

150



QC2- Inspect parts off machine FAI/FAIR

0.00

QC

Quality Control

Memo

0.00

x17

SL

11/05/13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-3 PAR #: N/A Fault Category: Thermoflowing NCR: Yes No DQA: H Date: 11/05/17
 11/05/17 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/05/18

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/13	140	Too Much Heat, clothe pattern transferred to part.	11/05/13 QSIOTZ	Scrap 1 part	Wk 11/05/13	S	11/05/13 QSIOTZ.	S 11/05/13
		RC: Res Move - LOA (employee work a call)						

NOTE: Date & initial all entries

Work Order ID 69556

Thursday, May 12, 2011 8:25:04 AM



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Setup Start



Revision ID:

Item Name: Window

Stop



Start Date: 5/12/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



HAND FINISHING THERMOFORMING

0.00

Thermoform
Thermoforming Machine

Memo

0.00

Water sand and buff to remove scratches if required

x17

BL
1105/13

180



QC5- Inspect part completeness to step on W/O

0.00

S. Wust/13

QC
Quality Control

Memo

0.00

(47)

190



Identify as per dwg & Stock Location _____

0.00

Tank 3 for w/o 68962

Packaging
Packaging

Memo

0.00

BL
1105/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Work Order ID 69556

Thursday, May 12, 2011 8:25:04 AM



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Item ID: D3290-3

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Revision ID:

Item Name: Window

Stop



Start Date: 5/12/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

200



QC

Quality Control

Operation
Description

QC21-Final inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan

Accept
QtyReject
QtyReject
NumberInsp.
Stamp

Memo

0.00

 MF
 11-05-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 8:25:01 AM

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Work Order ID: 69556



Parent Item: D3290-3



Parent Item Name: Window

Start Date: 5/12/2011

Required Date: 5/17/2011

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP A 04.08.18 New issue KJ/RF
IPP B 06.05.09 Ecn 798 EC IPP Rev.
C Removed QC8 Step 160 11/04/11 DL
IPP C 07.05.29 Thermoform in-house DL
IPP D 07.09.28 rev C dwg EC verified by: DD
IPP E 07.11.28 Add --Hand finish deburring DI

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	st	352.9934	3	50.52632	64.		

1/8" Polycast II Sheet



Location	Loc Qty	Loc Code
MAT	206.2467	
117431	206.2467	117431
MAT018	142.2467	
117324	68.7667	
117340	73.48	
MAT019	4.5	
115338	4.5	

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

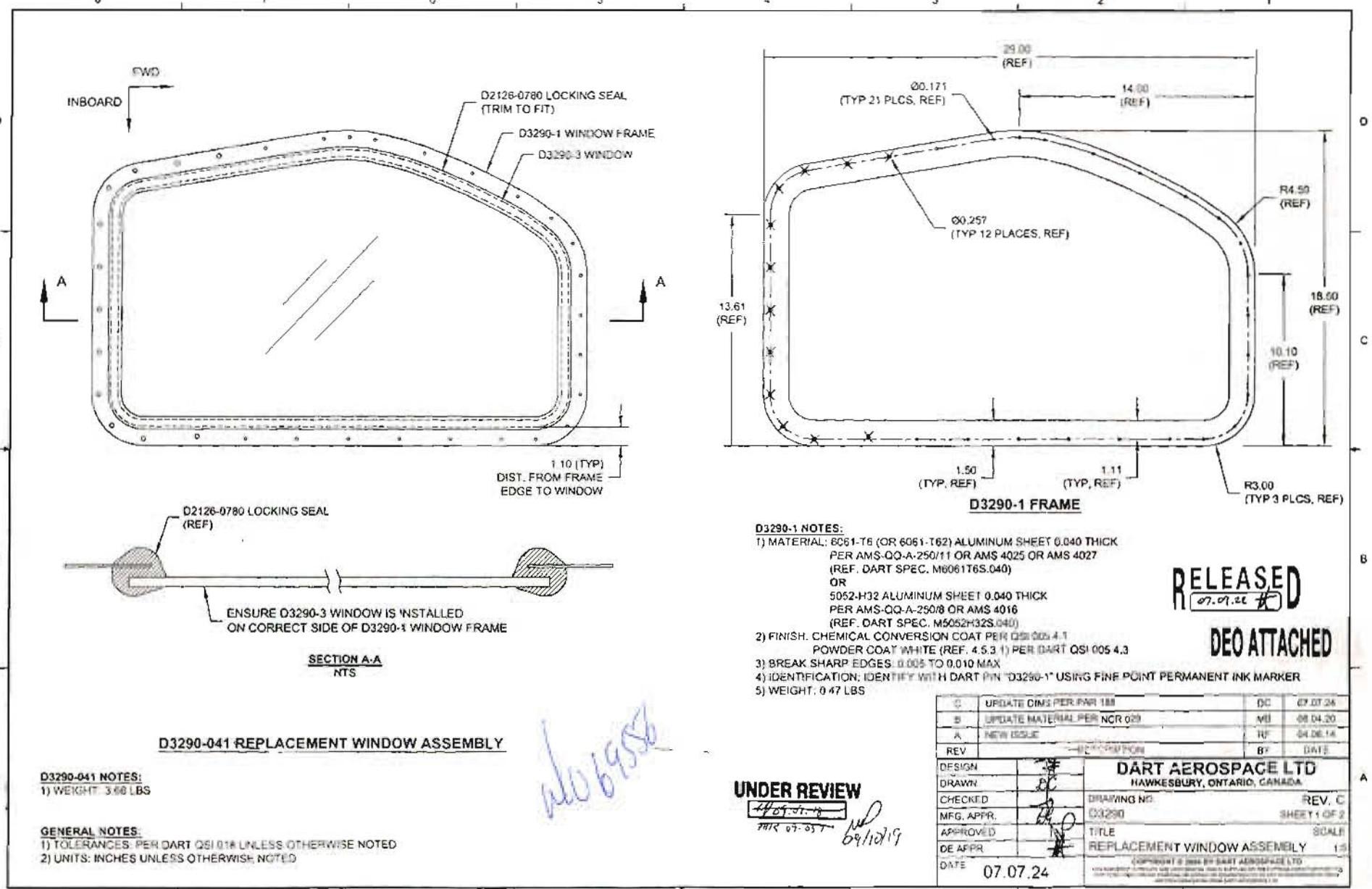
DART AEROSPACE LTD	Work Order:	67550
Description: Window	Part Number:	D3290-3
Inspection Dwg: D3290	Rev: C	Page 1 of 1

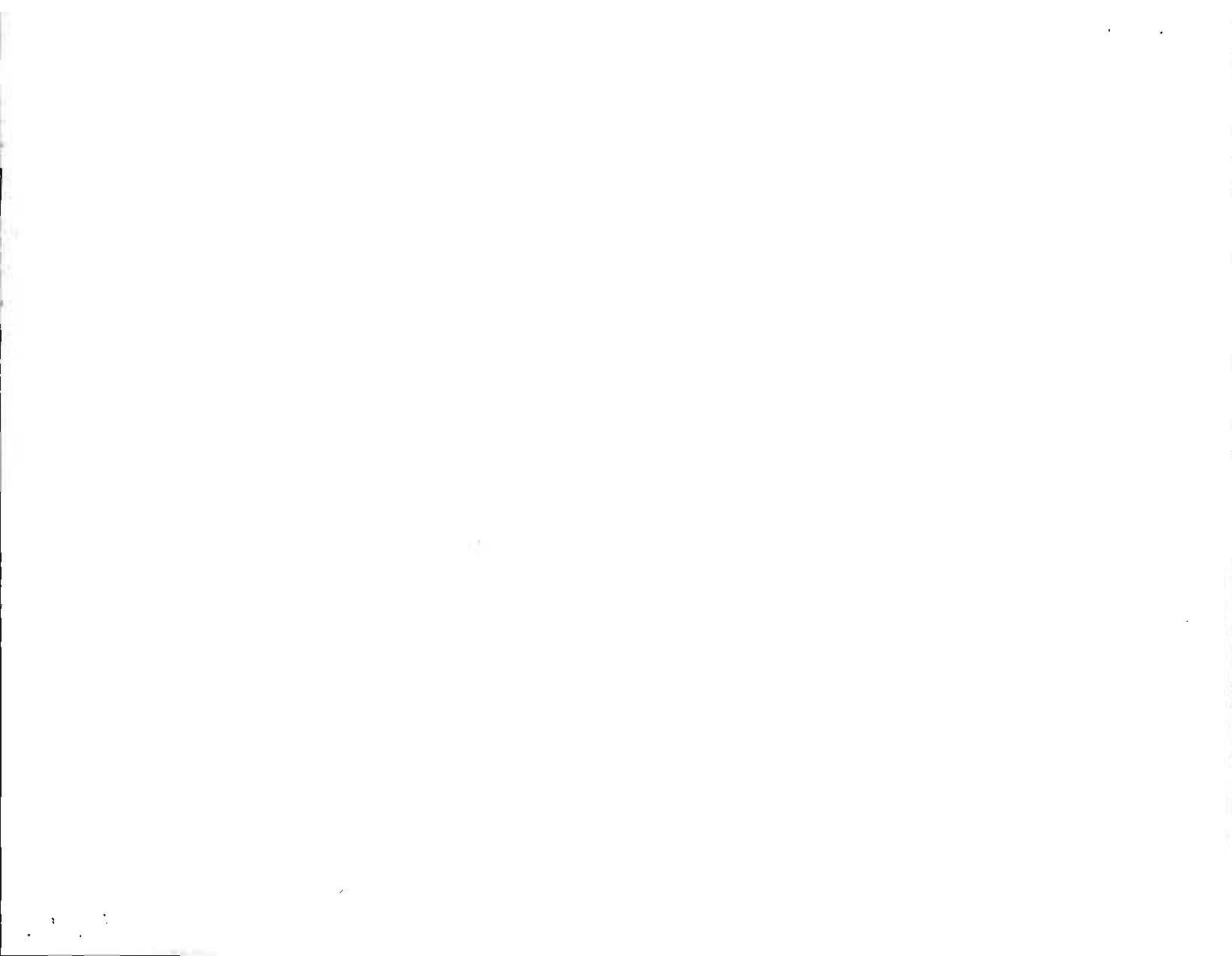
FIRST ARTICLE INSPECTION CHECKLIST

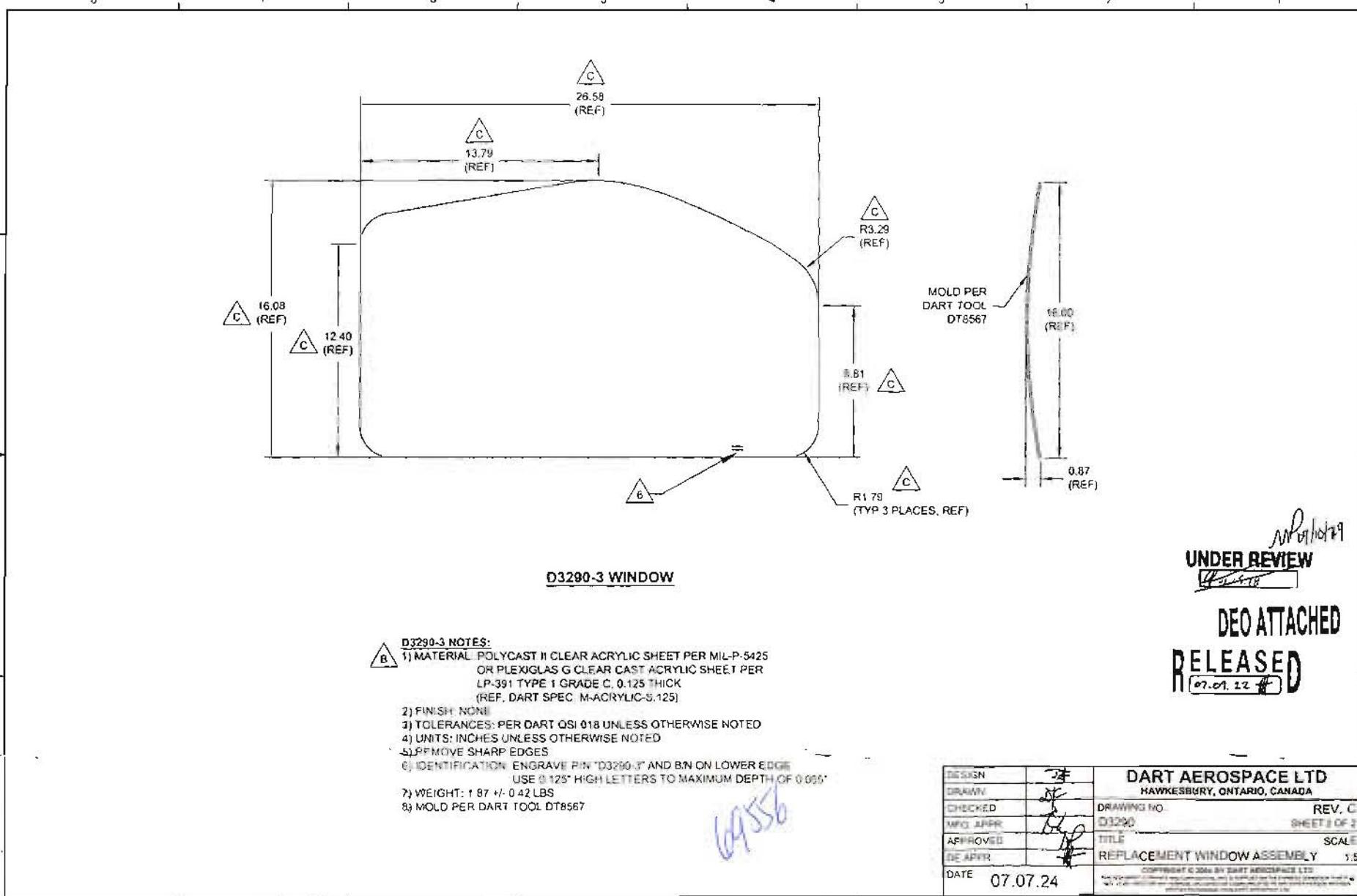
First Article Prototype

Measured by:	<u>H</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	11-5-12	Date:	WESLR	Date:	N/A

Rev	Date	Change	Revised by,	Approved
A	08.01.16	New Issue	KJ/EC/DD	







DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>gp</i>	CHECKED <i>ls</i>	MFG. APPR. <i>EZ</i>	APPROVED <i>WJ</i>	DE APPR. <i>WT</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21	DATE 09/09/21	

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040) REF. DART SPEC. M6061T6S.063 (REPLACE)
OR
5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040) REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
2009-10-09

